

Split

Ship DEC 2nd

Work Order ID 153319-2

Wednesday, November 16, 2016 9:57:14 AM

647.1702
B153319
REV. E

153319

Page 1

Item ID: 647.1702

Revision ID:

Item Name: Skid Deflector Assembly

Start Date: 11/28/2016 Start Qty: ~~6.00~~

Required Date: 12/6/2016 Req'd Qty: 6.00

Reference:

6

6

N900040100

Cust Item ID:

Customer:

Setup Start *NS1*

Stop *NS2*

Approvals: Process Plan: *VS* DAS 21 9-89 Date: *12/11/16* Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
647.1700	E

110	Pick Kit	0.00
-----	----------	------

110

Packaging

Packaging

Memo

0.00

6 DAS 6 9-89

DEC 15 2016

120		0.00
-----	--	------

120

Small Fab

Small Fab

Memo

1- Assemble item 4,6,7 and 8 as per dwg.

2- Clamp item 1 and 2 to item 3. Transfer drill holes as per dwg see note 6. Use clecos.

3- Disassemble parts

4- Deburr

5- Touch up expose aluminum with alodine

6- Re-assemble as per dwg

0.00

0.49

14 *17/01/10* DAS 36 9-89

Page 2

Wednesday, November 16, 2016 9:57:14 AM

Reference:

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

Work Order ID 153319

Wednesday, November 16, 2016 9:57:14 AM

153319

Page 3

Item ID: 647.1702

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skid Deflector Assembly

Start Date: 11/28/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 12/6/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Small Fab	Memo ASSEMBLE AS PER DWG	0.00							
		0.00							
200 *200* QC	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.02							
210 *210* Packaging	Identify as per dwg & Stock Location: _____	0.00							
	Memo	0.01							
	IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV								

DAS
6
9-89

JAN 16 2017

DAS
21
9-89

JAN 16 2017

Work Order ID 153319

Wednesday, November 16, 2016 9:57:14 AM

153319

Page 4

Item ID: 647.1702 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Skid Deflector Assembly
Start Date: 11/28/2016 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 12/6/2016 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC21- Final Inspection - Work Order Release	0.00					DAS 21 9-89		
220									
QC	Memo	0.10							
Quality Control									

DAS
21
9-89 JAN 16 2017

Picklist Print

Page 1

Wednesday, November 16, 2016 9:57:30 AM

Work Order ID: 153319

153319

Parent Item: 647.1702

647 1702

Parent Item Name: Skid Deflector Assembly

Start Date: 11/28/2016

Required Date: 12/6/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 13.07.17 JLM VERIFIED BY:DD IPP
REV:B 14.09.26 AS PER DWG C1 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21042-3	MS21042L3	Purchased	No				Each	0.0000		6			
MS21042-3									**	135945	DAS 6 9-89	DEC 15 2016	
Nut													
647.1712		Manufactured	No				Each	1.0000		6			
647 1712									**	153320	DAS 6 9-89	DEC 15 2016	
Gusset													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					CCK031	1							
					138336	1							
647.1713		Manufactured	No				Each	17.0000		6			
647 1713									**				
Spacer													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					CCK108	17							
					104845	17							
601.1915	CR3213-4-4	Purchased	No				Each	0.0000		132			
601 1915									**				
Rivet (CR3213-4-4)													
601.1607	NAS1149F0332P	Purchased	No				Each	19.0000		12			
601 1607									**	135949	DAS 6 9-89	DEC 15 2016	
Washer (NAS1149F0332P)													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST522	19							
					m123185	19							

DAS 36 9-89

Picklist Print

Wednesday, November 16, 2016 9:57:30 AM

Page 2

Work Order ID: 153319

153319

Parent Item: 647.1702

647 1702

Parent Item Name: Skid Deflector Assembly

Start Date: 11/28/2016

Required Date: 12/6/2016

Start Qty: 6.00

Required Qty: 6.00

601.1622 MS27039-1-14 Purchased No

Each 0.0000

6

601 1622

**

124326

DAS 6 DEC 15 2016

Screw(MS27039-1-14)

647.1714 Manufactured No

Each 0.0000

6

647 1714

**

153321

DAS 6 DEC 15 2016

Plate

647.1715 Manufactured No

Each 0.0000

6

647 1715

**

153189x5

DAS 6 DEC 15 2016

Plate

153322x1

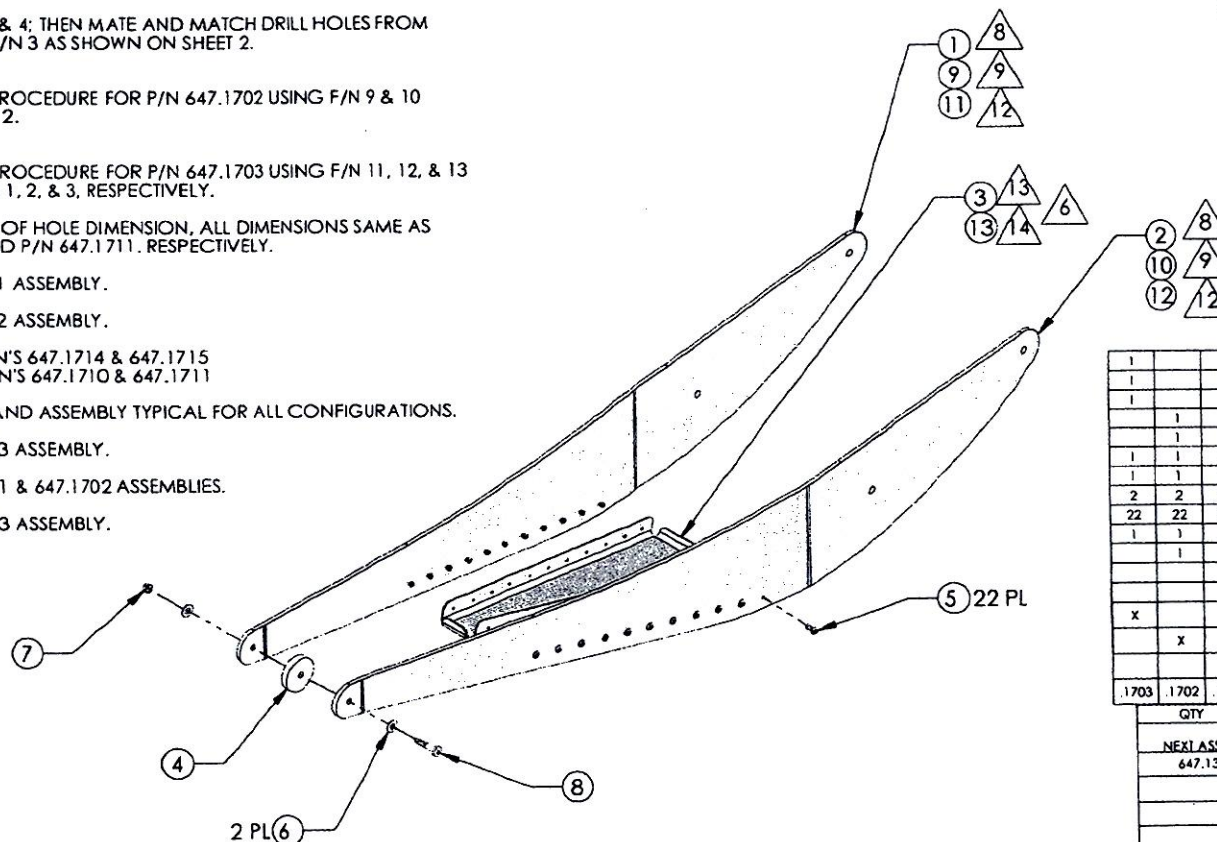
DAS 6 9-89

JAN 16 2017

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NOTES:

- 1 MATERIAL: 7075-T6 ALUMINUM PER AMS-QQ-A-250/12.
- 2 MATERIAL: 6061-T6 ALUMINUM BAR IAW AMS-QQ-A-250/11.
- 3 FINISH IAW MPP-172, SECTIONS 2.1, 3.1, & 4.2.
4. DEBURR AND BREAK ALL SHARP EDGES.
5. IDENTIFY IAW MPP-120.
- 6 P/N 647.1701:
CLAMP F/N 1, 2, & 4; THEN MATE AND MATCH DRILL HOLES FROM F/N 1 & 2 ONTO F/N 3 AS SHOWN ON SHEET 2.
- P/N 647.1702:
FOLLOW SAME PROCEDURE FOR P/N 647.1702 USING F/N 9 & 10 IN PLACE OF 1 & 2.
- P/N 647.1703:
FOLLOW SAME PROCEDURE FOR P/N 647.1703 USING F/N 11, 12, & 13 IN PLACE OF F/N 1, 2, & 3, RESPECTIVELY.
- 7 WITH EXCEPTION OF HOLE DIMENSION, ALL DIMENSIONS SAME AS P/N 647.1710 AND P/N 647.1711. RESPECTIVELY.
- 8 FOR P/N 647.1701 ASSEMBLY.
- 9 FOR P/N 647.1702 ASSEMBLY.
- 10 .323" DIA FOR P/N'S 647.1714 & 647.1715
.257" DIA FOR P/N'S 647.1710 & 647.1711
- 11 RIVET SPACING AND ASSEMBLY TYPICAL FOR ALL CONFIGURATIONS.
- 12 FOR P/N 647.1703 ASSEMBLY.
- 13 FOR P/N 647.1701 & 647.1702 ASSEMBLIES.
- 14 FOR P/N 647.1703 ASSEMBLY.



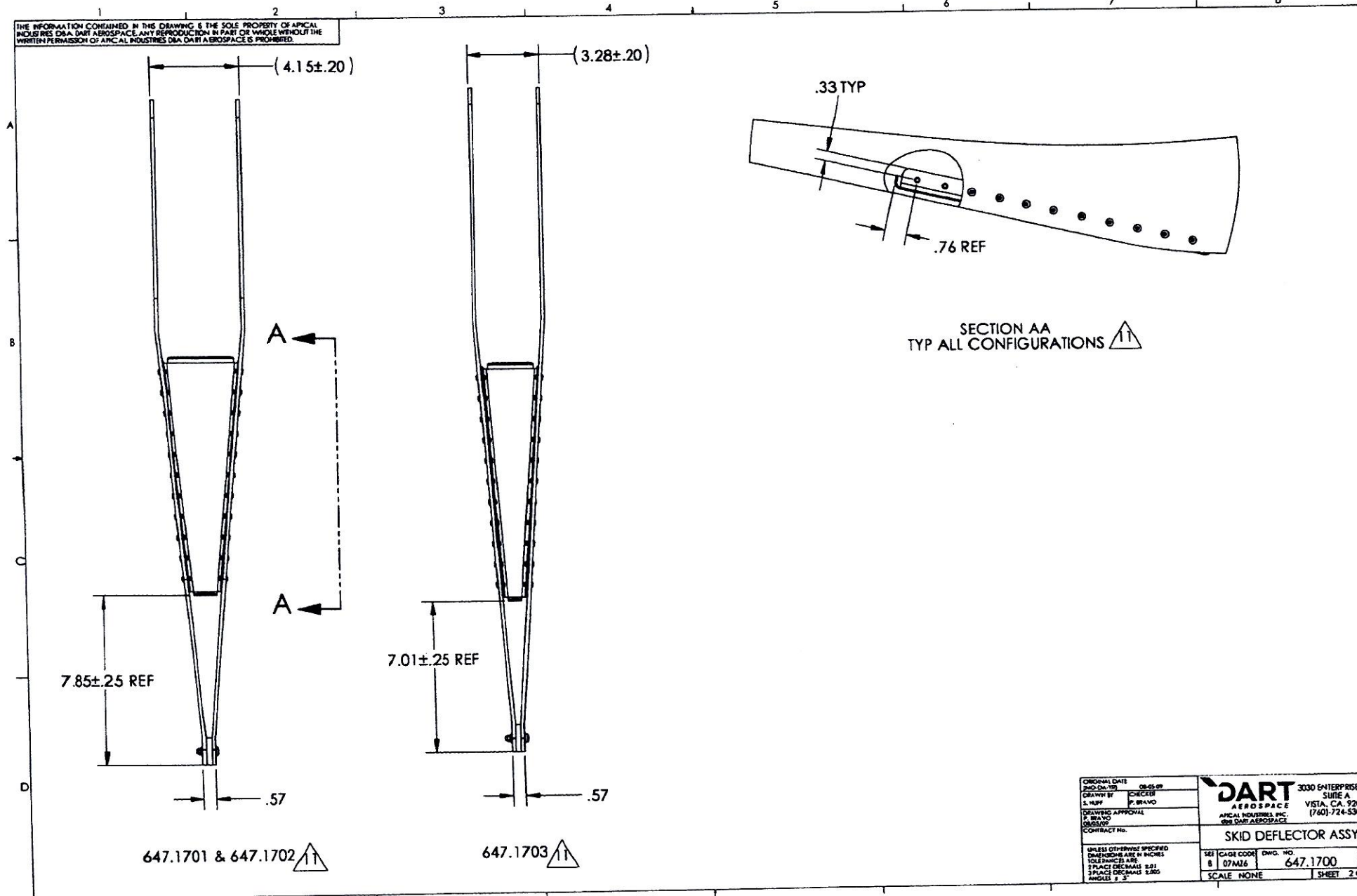
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISION: P82		N/C
N/C	INITIAL RELEASE	08/05/09	P. BRAVO
A	INCORPORATED ECN'S 02937 & 03921	06/02/13	P. BRAVO
B	INCORPORATED ECN 03970	07/03/13	P. BRAVO
C	INCORPORATED ECN 04058	08/14/13	P. BRAVO
D	INCORPORATED ECN'S 04619, 04702 & 04964	05/29/15	P. BRAVO
E	INCORPORATED ECN 05357	03/21/16	P. BRAVO

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY *Vic 62*
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *153319* *16/1/16*

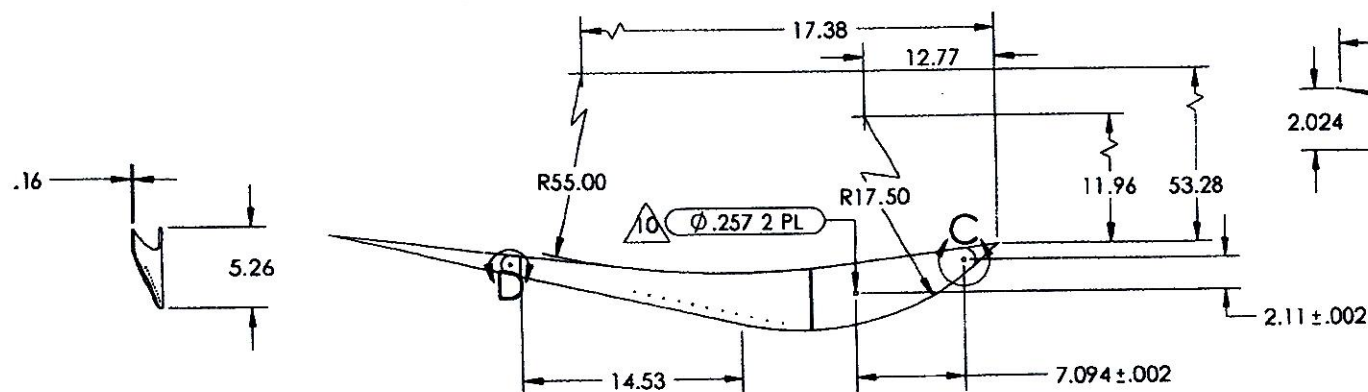
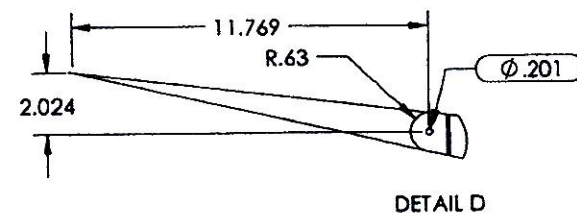
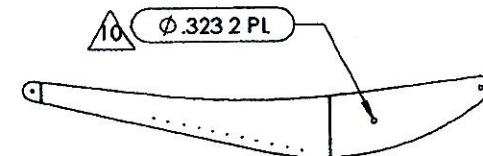
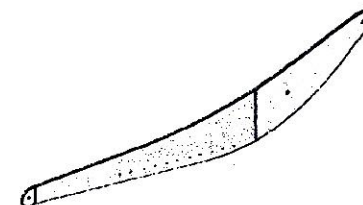
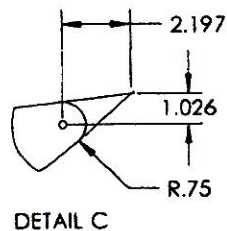
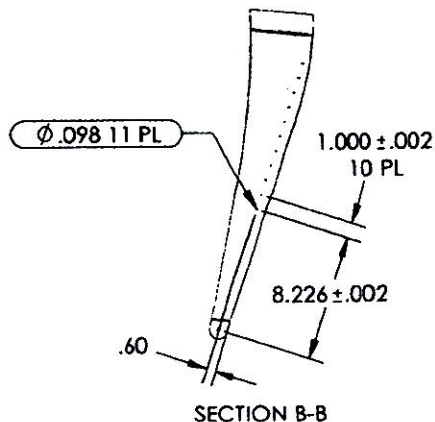
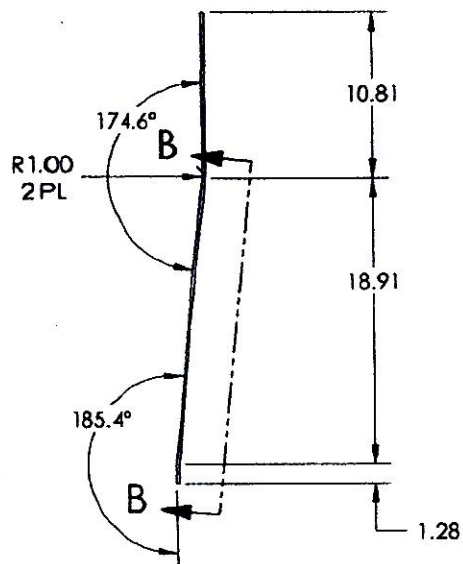
1		13	647.1718	GUSSET		
1		12	647.1717	PLATE		
1		11	647.1716	PLATE		
1	1	10	647.1715	PLATE		
1	1	9	647.1714	PLATE		
1	1	8	601.1622	SCREW	MS27039-1-14	
1	1	7	601.2943	LOCKNUT	MS21042-3	
2	2	6	601.1607	WASHER	NAS1149F0332P	
22	22	5	601.1915	RIVET	CR3213-4-4	
1	1	4	647.1713	SPACER		
1	1	3	647.1712	GUSSET		
	1	2	647.1711	PLATE		
	1	1	647.1710	PLATE		
X			647.1703	SKID DEFLECTOR ASSY		
X			647.1702	SKID DEFLECTOR ASSY		
	X		647.1701	SKID DEFLECTOR ASSY		

1703	1702	1701	PARTS LIST	
QTY			ORIGINAL DATE 08/05/09	
NEXT ASSY (S)			DRAWN BY: S. HUFF	
647.1300			CHECKED BY: P. BRAVO	
			DRAWING APPROVAL: P. BRAVO	
			CONTRACT NO.	
			UNLESS OTHERWISE SPECIFIED	
			DIMENSIONS ARE IN INCHES	
			TOLERANCES ARE:	
			2 PLACE DECIMALS ± .01	
			3 PLACE DECIMALS ± .005	
			ANGLES ± .5°	
			DART AEROSPACE 3030 ENTERPRISE CT., SUITE A, VISTA, CA. 92081 (760)-724-5300	
			SKID DEFLECTOR ASSY	
			SPT CLOS CODE	ENCL. NO.
			B 07M26	647.1700
			SCALE: NONE	SHEET 1 OF 7

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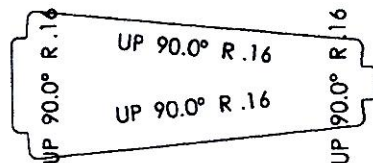
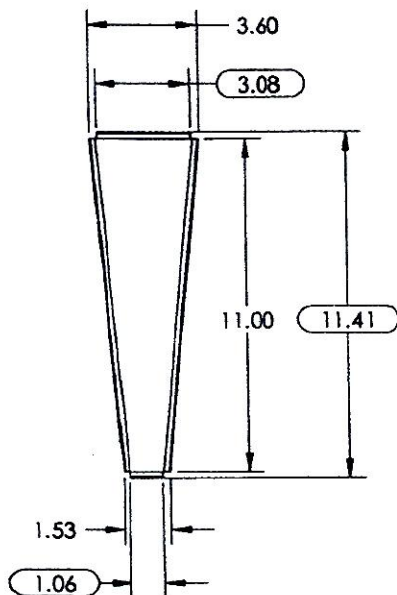


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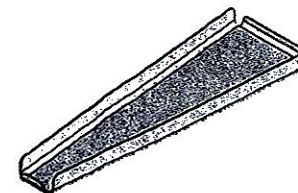


ORIGINAL DATE 08-20-99		3030 ENTERPRISE CT., SUITE A	
DRAWN BY CHECKER		VISTA, CA. 92081	
BY REV		(760) 724-5300	
DESIGNED APPROVED		APICAL INDUSTRIES INC.	
CHECKED		SKID DEFLECTOR ASSY	
CONTRACT NO.		SCALE NONE	
UNLESS OTHERWISE SPECIFIED		REV	DATE
DIMENSIONS ARE IN INCHES		B	07/01/06
TOLERANCES ARE:		QWG NO.	647.1700
2 PLACE DECIMALS $\pm .01$		REV	E
3 PLACE DECIMALS $\pm .005$		SHEET	3 OF 7
ANGLES $\pm .5^\circ$			

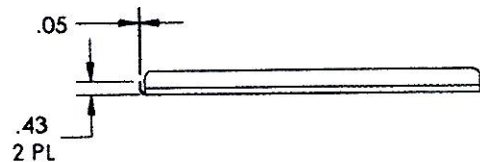
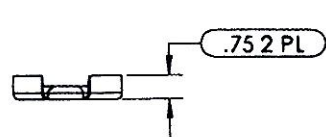
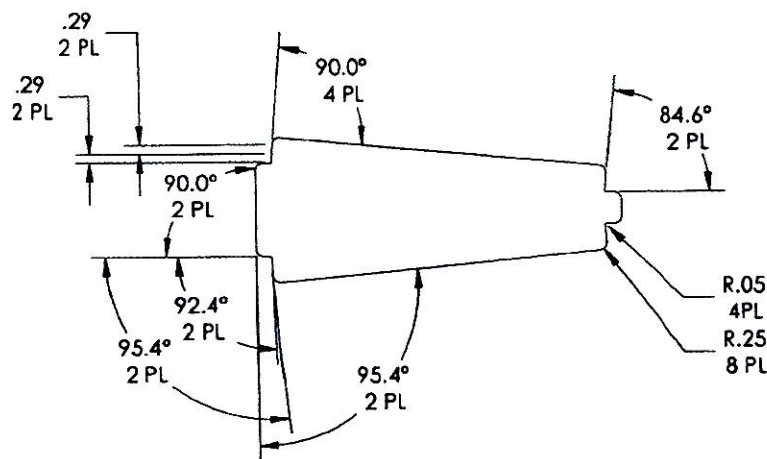
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FLAT PATTERN



647.1712

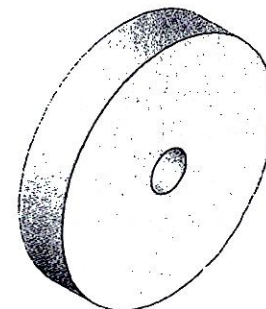
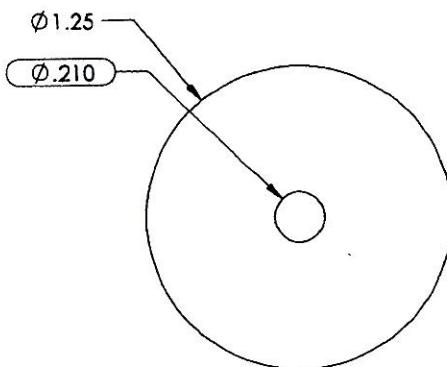
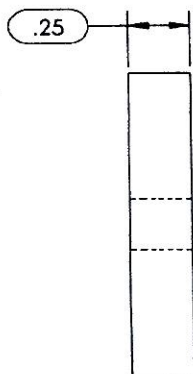


ORIGINAL DATE (MM-DD-YY)	05-05-97	 DART AEROSPACE P.O. BOX 10000 SAN ANTONIO, TEXAS 78210 PH: 214-349-0000 FAX: 214-349-0001 WWW.DART-AEROSPACE.COM	3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760)-724-5200
DRAWN BY S. RUFF	P. BRAVO		
CHECKED BY P. BRAVO			
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 ANGLES ± 5°		SKID DEFLECTOR ASSY	
REV B	CAGE CODE 07M16	ENG. NO. 647.1700	REV. E
SCALE NONE		SHEET 4 OF 7	

DART 3030 ENTERPRISE CT., SUITE A
AEROSPACE VISTA, CA. 92081
APICAL INDUSTRIES INC. (760)-724-5300
DBA DART AEROSPACE

SKID DEFLECTOR ASSY

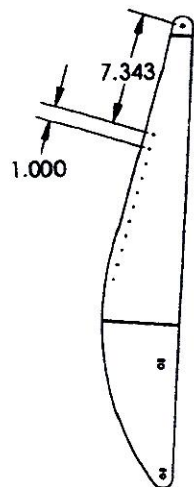
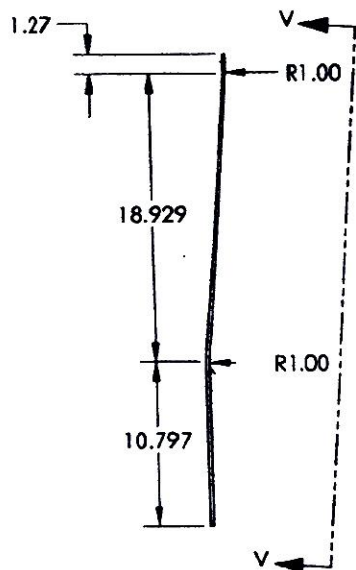
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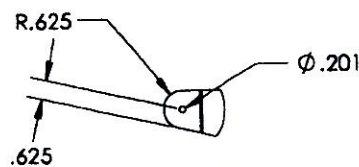
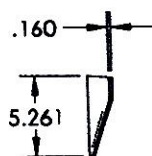
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ORIGINAL DATE 08-05-09		3030 ENTERPRISE CT. SUITE A VISTA, CA 92081 (760)-724-5300	
DRAWN BY L. HET P. BRAVO		DART AEROSPACE APICAL INDUSTRIES INC. DBA DART AEROSPACE	
DRAWING APPROVAL P. BRAVO 08-05-09		SKID DEFLECTOR ASSY	
CONTRACT NO.		SHEET 8	REV E
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 ANGLES ±.5°		CAGE CODE 07M16	DWG. NO. 647.1700
		SCALE NONE	SHEET 5 OF 7

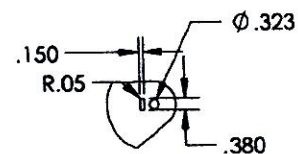
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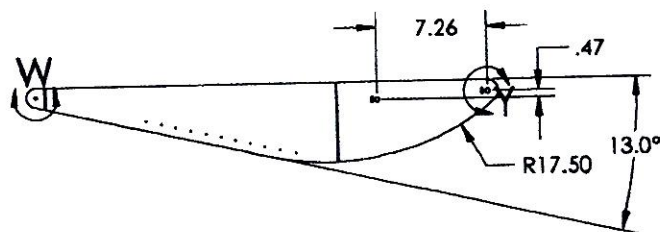
VIEW V-V



DETAIL W

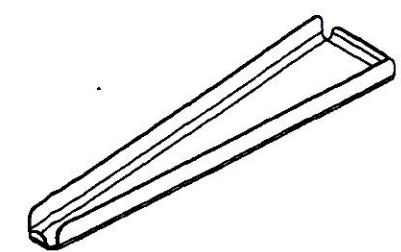
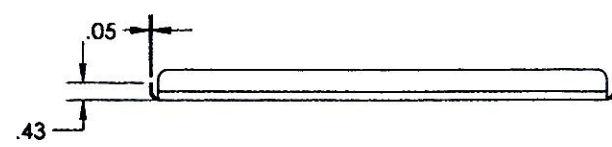
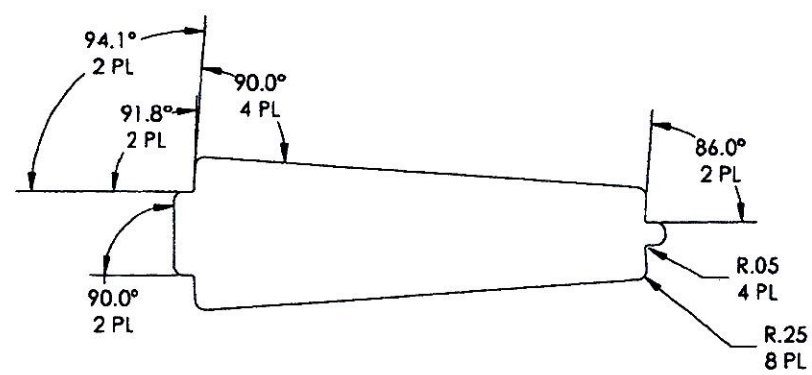
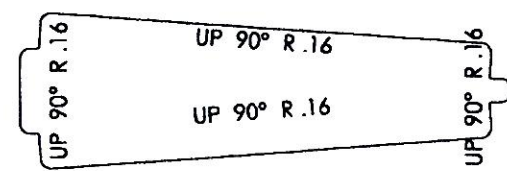
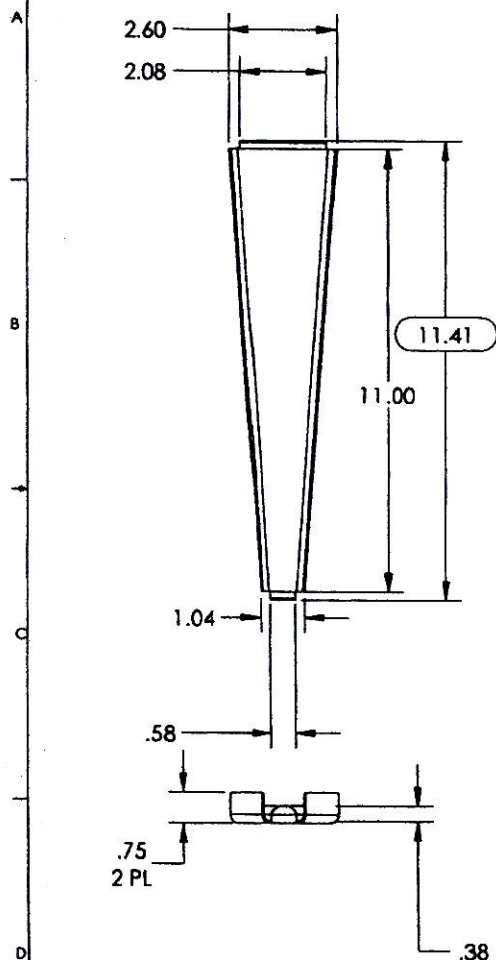


DETAIL Y
TYP 2 PL



ORIGINAL DATE 10-04-18	DESIGNER L. HUPP	DART AEROSPACE		3030 ENTERPRISE CT. SUITE A VISTA, CA 92081 (760)-724-5300
DRAWING APPROVAL P. BALVO	CHECKER P. BALVO	APCAL INDUSTRIES INC. DBA DART AEROSPACE		
CONTRACT NO.		SKID DEFLECTOR ASSY		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°	SIZE B	CAGE CODE 07NM26	DWG. NO. 647.1700	REV. E
SCALE NONE		SHEET 6 OF 7		

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647.1718

ORIGINAL DATE 1980-04-15		3030 ENTERPRISE CT. SUNNYVALE, CA 94086	
DRAWN BY S. HART	CHECKED P. BRAVO	APICAL INDUSTRIES, INC. DBA DART AEROSPACE	
DRAWING APPROVAL A. BRAVO		SKID DEFLECTOR ASSY	
CONTRACT NO.		SHEET 7 OF 7	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.005 ANGLES ±.5°		REV B 07/86	647.1700 E
SCALE: NONE			